



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3562-042
Job Sheet 168754



Part No: D3562-042

Job Qty: 2 ea

1x

Part Name: Step Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/17

Job Tracking No:

Created By: Linda Lacelle

Due Date: 12/8/17

Type: Stock

Description:

Note: DWG REV G IPP Rev:A New Issue 06-11-09 JLM IPP rev B ECN 987 07.10.09 EC verified by: DD IPP Rev:C ECN1048 07-12-18 DD verified by: EC IPP Rev:D 08-07-28 add chemical conversion coat DD ver:EC IPP REV:E 13.06.03 PER DWG REV:F DD VERF:JLM IPP REV:F 16.06.23 AS PER DWG REV.G DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	12/7/17	12/7/17	0.00	0.00	Start Up Large Fab-2		D.M. 17-11-22
100	Large Fab	2 pcs	12/7/17	12/7/17	0.00	2.83	Large Fab 8		D.M. 17-11-22
110	QC	2 pcs	12/7/17	12/7/17	0.00	0.00	QC5		CPC
120	HandFinish	2 pcs	12/7/17	12/7/17	0.00	0.50	HandFinish1		2017-12-04 JSL
130	QC	2 pcs	12/7/17	12/7/17	0.00	0.00	QC7		17-12-18
140	Small Fab	2 pcs	12/7/17	12/7/17	0.00	4.50	Small Fab		17-12-18
150	QC	2 pcs	12/7/17	12/7/17	0.00	0.00	QC5		CPC
160	Large Fab	2 pcs	12/7/17	12/7/17	0.00	2.83	Large Fab 2		CPC
170	QC	2 pcs	12/7/17	12/7/17	0.00	0.00	QC10		CPC
180	QC	2 pcs	12/7/17	12/7/17	0.00	0.00	QC5		CPC
190	HandFinish	2 pcs	12/7/17	12/7/17	0.00	0.50	HandFinish1		BEB 17/12/19
200	Powdercoat	2 pcs	12/7/17	12/7/17	0.00	0.67	Powdercoat1		BE 17-12-20
210	HandFinish	2 pcs	12/8/17	12/8/17	0.00	0.50	HandFinish3		BEB 17/12/21
215	QC	2 pcs	12/8/17	12/8/17	0.00	0.00	QC3		17-12-21
220	QC	2 pcs	12/8/17	12/8/17	0.00	0.00			
230	Packaging	2 pcs	12/8/17	12/8/17	0.00	0.00	Packaging3		
240	QC21-SA	2 Ea	12/8/17	12/8/17	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2622 extrusion as per Dwg D3562 85.150

Descriptions: 140 - 1- Transfer drill Rivet holes as per dwg D3562.

160 - 1-Weld end caps as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

200 - START TIME: 8:25 O.V.T. 320° FINISH: 8:55.

M 138467

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2622-120C F162484-2	2	112	0	0
140-Small Fab	D2734 S012001	4	100	0	0
	- D3560-042 S021825	2	0	0	0
	D3560-044 S021862	2	0	0	0
	MS20600-AD4W4 S016823	64	42	0	0

Part Specifications

Specifications could not be found.

Plex 11/22/17 12:56 PM dart.lacelle.linda

DART
AEROSPACE
S024756



Step Weldment

PART NO:
Revision:
Operation:
Change No:

D3562 - 042

QC

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Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 12/19/17
Job No:

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☒</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☒	Composite ☐	Supplier ☐																																																	
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Date : <u>17-12-18</u>		Step #: <u>1410</u>		QTY Effective : <u>①</u>		MRB (QSI042) Approval																																																																			
Description Work Order Deviation				Disposition																																																																					
Found during assembly that qty 1 of D3560-042 was incorrect. It was welded using an incorrect arm. R.C. arm D3560-2 B164463 was actually fabricated has a D3560-1				Scrap destroy step extrusion and D3560-042. Restock D3560-044 5021862 no replace Create work order to restock qty 5 of D3560-2 B164463 has D3560-1																																																																					
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